

Date: Thursday, 04/09/2008 1:25:33 PM
 User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: SPACER
Job Number	: 41844		
Estimate Number	: 10683		
P.O. Number	:	Part Number	: D34551
This Issue	: 04/09/2008 S.O. No. :	Drawing Number	: D3455 REV.A
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : MACHINED PARTS	Drawing Revision	: A
Previous Run	: 38782	Material	:
Written By	:	Due Date	: 20/09/2008 Qty: 40 Um: Each
Checked & Approved By	: <u>JUL 08.9.04</u>		
Comment	: EST REV. A 05.11.17 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MDELNR1000	Delrin Round Bar 1"
-----	------------	---------------------



Comment: Qty.: 0.0231 f(s)/Unit Total: 0.9240 f(s)
 Delrin Round Bar 1"
 (M-DELRIN-R1.000)
 Batch: M108752 *mmf 08/09/14*



2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDHINGE COBRA
 1-TURN AS PER FOLIO FA583 & DWG D3455,
 FOLIO REV: AA
 DWG REV: A



2-DEBURR AS REQUIRED

mmf 08/09/14

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mmf 08/09/14

4.0	QC8	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

26 08/09/16 (42)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1
 Deburr if necessary.

08/09/23 (42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 04/09/2008 1:25:33 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER

Job Number: 41844

Part Number: D34551

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counter

Comment: INSPECT WORK TO CURRENT STEP

5 08/08/23 (242)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



(2x)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *94*

8/9/23

54

8.0

QC21

FINAL INSPECTION/W/O RELEASE



08/09/24 *AF*

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 08-09-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

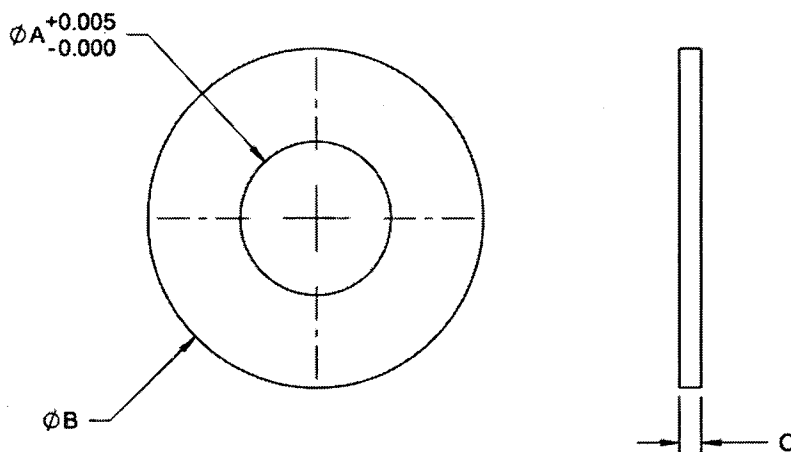
NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3455	REV. A SHEET 1 OF 1
DATE 05.09.02		TITLE SPACER	SCALE 2:1
A	05.09.02	NEW ISSUE	

RELEASED

05.12.09 *[Signature]*



D3455-X

1) SPECIFICATION: **D3455-X SPACER**

DASH No.

WHERE 'X' IS THE SIZE PER THE FOLLOWING TABLE:

DASH No.	A (in)	B (in)	C (in)
-1	0.453	1.00	0.065
-3	0.386	1.00	0.050

NOTES:

- 1) MATERIAL: DELRIN ROUND BAR (REF. DART SPEC. M-DELRIN-R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. **41844**

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